



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3290-1

Job Sheet 181227



Part No: D3290-1

Job Qty: 10 ea

Part Name: Frame



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP REV:A 12.06.13 NEW ISSUE DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		8/31/18	0.00	0.00	Start Up Waterjet		SC 18/08/23
100	Waterjet	10 pcs		8/31/18	0.00	2.09	Waterjet1		SC 18/08/23
120	QC	10 pcs		8/31/18	0.00	0.00	QC8		38
130	HandFinish	10 pcs		8/31/18	0.00	0.68	HandFinish1		D.R. 18/08/27
135	QC	10 pcs		8/31/18	0.00	0.00	QC7-2		PK 15-8-27
140	Powdercoat	10 pcs		8/31/18	0.00	0.48	Powdercoat1		PK 13-8-24
150	QC	10 pcs		8/31/18	0.00	0.00	QC3		DAS AUG 2 8 2018 68
180	Packaging	10 pcs		8/31/18	0.00	0.00	Packaging3-1	5432	6 9-89
190	QC21-SA	10 Ea		8/31/18	0.00	0.00	QC21	9-89	21 9-89

M 83893

START: 3:40

OUT: 3:00 FINISH: 4:10

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	37.5000 sf (3.75 ea)	90-Start up Operation	

5076996 (25)

(15.75)

5101049

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.063	38	139	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window Frame	29.000inches ± 0.030	29.030 28.970	29,000	
2	Window Frame	14.000inches ± 0.030	14.030 13.970	14,000	
3	Window Frame	0.171inches + 0.005 - 0.001	0.176 0.170	0,173	
4	Window Frame	1.500inches ± 0.030	1.530 1.470	1,507	
5	Window Frame	1.110inches ± 0.030	1.140 1.080	1,118	
6	Window Frame	10.100inches ± 0.030	10.130 10.070	10,107	

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS																																																																																																																																													
Part No. _____				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																																																																										
NCR No. _____				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																																																																										
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																																																																																										
Date :		Step #:		QTV Effective :		MRB (QSI042) Approval																																																																																																																																											
Description Work Order Deviation		 Completed By _____ / Supervisor _____ Verification _____ Coordinator _____ Approval _____ Container No: S105054  Part: D3290-1 Job No: 181227 Serial No/Batch: S105054 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 06/24/16																																																																																																																																															
Root Cause <table border="1"> <tr> <td>Environment</td> <td>☐</td> <td>No Re-verification</td> <td>☐</td> <td>Pressure/Fo</td> <td>☐</td> <td>Inspection Incomplete/Unqualified</td> <td>☐</td> <td>Wrong Stock Pulled</td> <td>☐</td> <td>Part Lost/Missing</td> <td>☐</td> </tr> <tr> <td>Design</td> <td>☐</td> <td>Operator</td> <td>☐</td> <td>Bending</td> <td>☐</td> <td>Contamination</td> <td>☐</td> <td>Out of Sequence</td> <td>☐</td> <td>Part Moved</td> <td>☐</td> </tr> <tr> <td>Doc/Data</td> <td>☐</td> <td>Offset/Setup</td> <td>☐</td> <td>Centre Not</td> <td>☐</td> <td>Countersink</td> <td>☐</td> <td>Off-set</td> <td>☐</td> <td>Drawing</td> <td>☐</td> </tr> <tr> <td>Equip/Tooling</td> <td>☐</td> <td>Supplier</td> <td>☐</td> <td>Cracks</td> <td>☐</td> <td>Cut Too Short</td> <td>☐</td> <td>Mislabeled</td> <td>☐</td> <td>Finish</td> <td>☐</td> </tr> <tr> <td>Handling/Pre</td> <td>☐</td> <td>Training</td> <td>☐</td> <td>Crimp/Kink/Ripple/Wave</td> <td>☐</td> <td>Instructions Incomplete/Unclear</td> <td>☐</td> <td>Fit/Function</td> <td>☐</td> <td>Misread</td> <td>☐</td> </tr> <tr> <td>Material</td> <td>☐</td> <td>Use for Testing</td> <td>☐</td> <td>Cuffs</td> <td>☐</td> <td>Drill Holes</td> <td>☐</td> <td>Misaligned/off center</td> <td>☐</td> <td>Turning Sequence</td> <td>☐</td> </tr> <tr> <td>Internal Transport</td> <td>☐</td> <td>Poor Information</td> <td>☐</td> <td>Crushing</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Tribal Knowledge</td> <td>☐</td> <td>Rushing</td> <td>☐</td> <td>Heat Treat</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>LOA</td> <td>☐</td> <td>Product Improvement</td> <td>☐</td> <td>Wave/Twist in Tube</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Substation</td> <td>☐</td> <td>Process Improvement</td> <td>☐</td> <td>Marks/Chatter</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date</td> <td>☐</td> <td>Manufacturing Process</td> <td>☐</td> <td></td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Misidentified</td> <td>☐</td> <td>Past Due</td> <td>☐</td> <td>OTHER :</td> <td>☐</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>		Environment	☐	No Re-verification	☐	Pressure/Fo	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Design	☐	Operator	☐	Bending	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not	☐	Countersink	☐	Off-set	☐	Drawing	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐							Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐							LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐							Substation	☐	Process Improvement	☐	Marks/Chatter	☐							Past Expiry Date	☐	Manufacturing Process	☐		☐							Misidentified	☐	Past Due	☐	OTHER :	☐						
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7	Window Frame	18.500inches $\pm$ 0.030	18.530 18.470	18,500
8	Window Frame	0.063inches $\pm$ 0.010	0.073 0.053	0,062
9	Window Frame	3.000inches $\pm$ 0.030	3.030 2.970	3,003
10	Window Frame	4.500inches $\pm$ 0.030	4.530 4.470	4,502
11	Window Frame	0.257inches $\pm$ 0.006 - 0.001	0.263 0.256	0,259
12	Window Frame	13.610inches $\pm$ 0.030	13.640 13.580	13,612

Plex 7/24/18 9:40 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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